

Date: Thursday, 3/13/2008 10:19:08 AM  
User: Kim Johnston

# **Process Sheet**

|   |   |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services                                    | Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD) |
| Job Number : 37922  |   |
| Estimate Number : 10531   |   |
| P.O. Number :   | Part Number : D2572                                   |
| This Issue : 3/13/2008 S.O. No. :   | Drawing Number : D2572 REV E                          |
| Prsht Rev. : NC   | Project Number : N/A                                  |
| First Issue : / / Type : MACHINED PARTS   | Drawing Revision : E                                  |
| Previous Run : 37565  | Material :  |
| Written By :  | Due Date : 4/4/2008 Qty: 10 Um: Each                  |
| Checked & Approved By : <u>08 03 13</u>   |   |
| Comment : Est. 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ |   |

## **Additional Product**

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |          |                         |
|-----|----------|-------------------------|
| 1.0 | D6101005 | 7075-T7351 8.25X5.0X2.5 |
|-----|----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2572  
Ensure that grain is along 5.00" length  
Batch No: B34874

ml 08/03/02

10

|     |       |                                |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 37922 Double check by: DJP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove shap edges.

ml / J.L 08/04/02

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

ml / J.L 08/04/02

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/04/02

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37922

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 08/04/02

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/04/02

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

BR

08-04-03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL

AS

08-04-03

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS 08/04/04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



U 08.04.04

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|   |                     |                    |
|---|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>               | <b>Work Order:</b>  | <b>37922</b>       |
| <b>Description: Saddle, Fwd Inboard</b> | <b>Part Number:</b> | <b>D2572</b>       |
| <b>Inspection Dwg: D2572 Rev. E</b>     |                     | <b>Page 1 of 1</b> |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.438 | 0.443 |                | .440                       | .440  | .440  | .440  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 8.000                      | 8.000 | 8.001 | 8.001 |    |      |
| F             | 0.490 | 0.510 |                | .502                       | .502  | .507  | .502  |    |      |
| G             | 0.257 | 0.262 |                | .266                       | .260  | .260  | .260  |    |      |
| H             | 0.375 | 0.380 |                | .378                       | .378  | .378  | .378  |    |      |
| I             | 0.490 | 0.510 |                | .499                       | .499  | .495  | .500  |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .570                       | .569  | .565  | .568  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.490 | 1.500 |                | 1.495                      | 1.495 | 1.496 | 1.495 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.499 | 2.499 | 2.500 |    |      |
| O             | 3.869 | 3.879 |                | 3.871                      | 3.873 | 3.872 | 3.873 |    |      |
| P             | 0.115 | 0.135 |                | .126                       | .129  | .126  | .125  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | .249                       | .254  | .252  | .251  |    |      |
| S             | 0.115 | 0.135 |                | .130                       | .132  | .133  | .127  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 2.940 | 2.980 |                | 2.959                      | 2.966 | 2.960 | 2.960 |    |      |
| V             | 0.230 | 0.250 |                | .237                       | .235  | .236  | .235  |    |      |
| W             | 0.115 | 0.135 |                | .125                       | .135  | .127  | .129  |    |      |
| X             | 0.307 | 0.312 |                | .309                       | .309  | .308  | .308  |    |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  | .760  | .760  |    |      |
| Z             | 0.352 | 0.372 |                | .258                       | .369  | .355  | .361  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .623                       | .623  | .626  | .625  |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .245                       | .243  | .246  | .246  |    |      |
| AE            | 1.375 | 1.395 |                | 1.387                      | 1.392 | 1.387 | 1.387 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | .266                       | .255  | .255  | .259  |    |      |
| AH            | 0.240 | 0.260 |                | .247                       | .245  | .247  | .245  |    |      |
| AI            | 2.000 | 2.020 |                | 2.001                      | 2.005 | 2.000 | 2.001 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |                 |
|--------------|-----------------|
| Measured by: | <i>MR / J.L</i> |
| Date:        | <i>08/04/02</i> |

|             |                 |
|-------------|-----------------|
| Audited by: | <i>S.S</i>      |
| Date:       | <i>08/04/02</i> |

| Rev | Date     | Change                                  | Revised by | Approved           |
|-----|----------|---|------------|--------------------|
| A   |          | New Issue                               | RF         |                    |
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |                    |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |                    |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |                    |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     | <i>[Signature]</i> |

|   |                     |                    |
|---|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>               | <b>Work Order:</b>  | <b>3722</b>        |
| <b>Description: Saddle, Fwd Inboard</b> | <b>Part Number:</b> | <b>D2572</b>       |
| <b>Inspection Dwg: D2572 Rev. E</b>     |                     | <b>Page 1 of 1</b> |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 15                         | 16    | 17    | 18    | By | Date |
| A             | 0.438 | 0.443 |                | .440                       | .440  | .440  | .440  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 8.001                      | 8.001 | 8.001 | 8.001 |    |      |
| F             | 0.490 | 0.510 |                | .503                       | .502  | .504  | .501  |    |      |
| G             | 0.257 | 0.262 |                | .260                       | .260  | .260  | .260  |    |      |
| H             | 0.375 | 0.380 |                | .378                       | .378  | .378  | .378  |    |      |
| I             | 0.490 | 0.510 |                | .499                       | .502  | .501  | .502  |    |      |
| J             | 1.174 | 1.184 |                | 1.178                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .576                       | .572  | .569  | .570  |    |      |
| L             | 1.174 | 1.184 |                | 1.178                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.490 | 1.500 |                | 1.495                      | 1.495 | 1.495 | 1.495 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| O             | 3.869 | 3.879 |                | 3.872                      | 3.874 | 3.874 | 3.874 |    |      |
| P             | 0.115 | 0.135 |                | .126                       | .125  | .125  | .125  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | .257                       | .250  | .250  | .250  |    |      |
| S             | 0.115 | 0.135 |                | .136                       | .129  | .126  | .125  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 2.940 | 2.980 |                | 2.959                      | 2.958 | 2.958 | 2.958 |    |      |
| V             | 0.230 | 0.250 |                | .235                       | .237  | .237  | .236  |    |      |
| W             | 0.115 | 0.135 |                | .127                       | .127  | .124  | .123  |    |      |
| X             | 0.307 | 0.312 |                | .309                       | .309  | .309  | .309  |    |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  | .760  | .760  |    |      |
| Z             | 0.352 | 0.372 |                | .362                       | .360  | .362  | .362  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .622                       | .623  | .621  | .623  |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .246                       | .248  | .246  | .244  |    |      |
| AE            | 1.375 | 1.395 |                | 1.387                      | 1.391 | 1.390 | 1.390 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | .260                       | .260  | .260  | .260  |    |      |
| AH            | 0.240 | 0.260 |                | .247                       | .245  | .248  | .246  |    |      |
| AI            | 2.000 | 2.020 |                | 2.000                      | 2.004 | 2.003 | 2.002 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |                  |
|--------------|------------------|
| Measured by: | <i>ML / J.L.</i> |
| Date:        | <i>08/04/01</i>  |

|             |                 |
|-------------|-----------------|
| Audited by: | <i>RF</i>       |
| Date:       | <i>08/04/01</i> |

| Rev | Date     | Change                                  | Revised by | Approved           |
|-----|----------|---|------------|--------------------|
| A   |          | New Issue                               | RF         |                    |
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |                    |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |                    |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |                    |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     | <i>[Signature]</i> |

|   |                           |
|---|---------------------------|
| <b>DART AEROSPACE LTD</b>               | <b>Work Order:</b> 37922  |
| <b>Description:</b> Saddle, Fwd Inboard | <b>Part Number:</b> D2572 |
| <b>Inspection Dwg:</b> D2572 Rev. E     | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

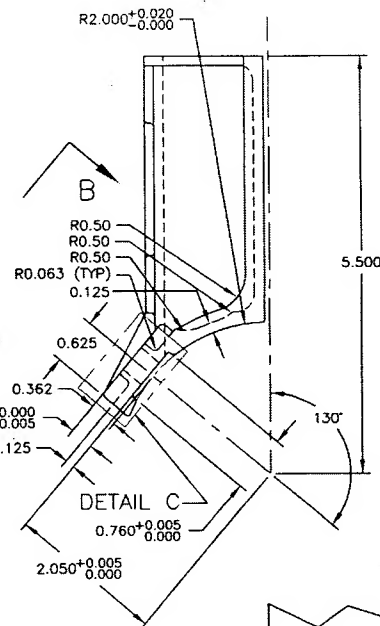
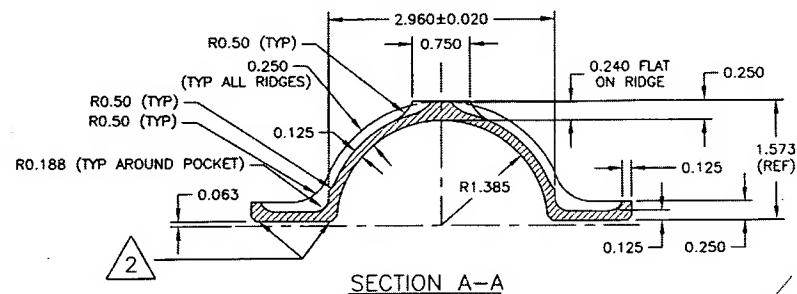
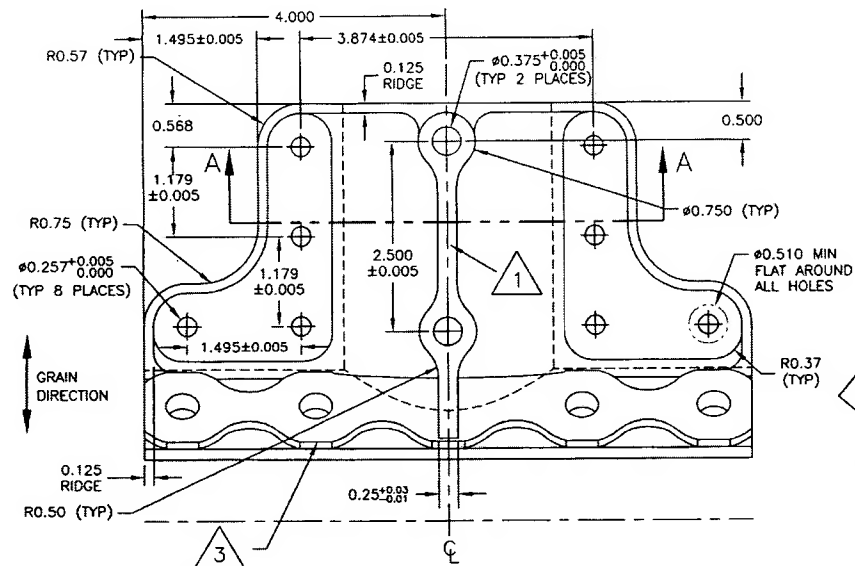
|               |       |       |                | Recorded Actual Dimensions |       |   |   |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 19                         | 210   | 3 | 4 | By | Date |
| A             | 0.438 | 0.443 |                | .440                       | .440  |   |   |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 |   |   |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 |   |   |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 |   |   |    |      |
| E             | 7.990 | 8.010 |                | 8.001                      | 8.001 |   |   |    |      |
| F             | 0.490 | 0.510 |                | .502                       | .501  |   |   |    |      |
| G             | 0.257 | 0.262 |                | .260                       | .260  |   |   |    |      |
| H             | 0.375 | 0.380 |                | .378                       | .378  |   |   |    |      |
| I             | 0.490 | 0.510 |                | .502                       | .502  |   |   |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 |   |   |    |      |
| K             | 0.558 | 0.578 |                | .564                       | .570  |   |   |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 |   |   |    |      |
| M             | 1.490 | 1.500 |                | 1.500                      | 1.500 |   |   |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| O             | 3.869 | 3.879 |                | 3.874                      | 3.874 |   |   |    |      |
| P             | 0.115 | 0.135 |                | .124                       | .124  |   |   |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  |   |   |    |      |
| R             | 0.240 | 0.260 |                | .250                       | .249  |   |   |    |      |
| S             | 0.115 | 0.135 |                | .126                       | .124  |   |   |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  |   |   |    |      |
| U             | 2.940 | 2.980 |                | 2.958                      | 2.958 |   |   |    |      |
| V             | 0.230 | 0.250 |                | .238                       | .238  |   |   |    |      |
| W             | 0.115 | 0.135 |                | .126                       | .125  |   |   |    |      |
| X             | 0.307 | 0.312 |                | .309                       | .309  |   |   |    |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  |   |   |    |      |
| Z             | 0.352 | 0.372 |                | .360                       | .360  |   |   |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  |   |   |    |      |
| AB            | 0.615 | 0.635 |                | .622                       | .623  |   |   |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  |   |   |    |      |
| AD            | 0.240 | 0.260 |                | .244                       | .242  |   |   |    |      |
| AE            | 1.375 | 1.395 |                | 1.389                      | 1.389 |   |   |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  |   |   |    |      |
| AG            | 0.240 | 0.280 |                | .260                       | .260  |   |   |    |      |
| AH            | 0.240 | 0.260 |                | .246                       | .247  |   |   |    |      |
| AI            | 2.000 | 2.020 |                | 2.002                      | 2.002 |   |   |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  |   |   |    |      |
| Accept/Reject |       |       |                |                            |       |   |   |    |      |

|              |          |
|--------------|----------|
| Measured by: | 3.1      |
| Date:        | 08/04/02 |

|             |          |
|-------------|----------|
| Audited by: | RF       |
| Date:       | 08/04/02 |





| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |

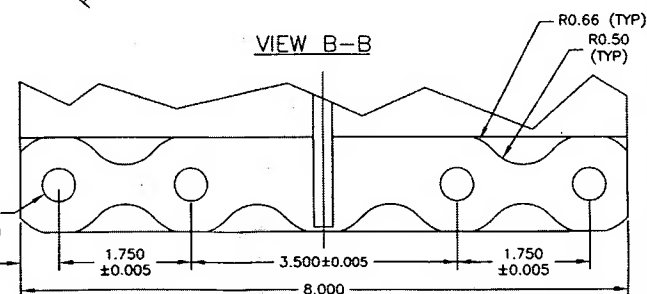
05.12.06 ~~11~~



## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063 x 45° ALL AROUND                                   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |



DETAIL C  
SCALE 2:1

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